

Date: Thursday, 6/15/2006 1:41:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 27557		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 6/15/2006 S.O. No. : N/A	Drawing Number	: D2577 REV-E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 24199	Material	: N/A
Written By	: <i>SAC</i> (Comment Below)	Due Date	: 6/30/2006
Checked & Approved By	: <i>KJ</i> 06-06-15	Qty:	<i>33</i>
Comment	: Est: F 02.09.24 Re-format: KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 1.0301 sf(s)/Unit Total : 51.5025 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: <i>M100473(22) M100473</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: <i>C</i> Prog Rev: <i>E</i>
		<i>SAC 06:06:27</i>
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1
		<i>SAC 06:06:28</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr
		<i>SAC 06:07:18 33</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.08.09 2.0		IP Part SCRAP. Hole away out of tolerance, from Water Jet.	QP 06.08.09 per QSI 042	Re-weld part. Use wear plate for weld test.	SAD 06.07.18 per QSI 042	✓ 06.07.18	QP 06.08.09 per QSI 042	✓ 06.06.28

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:41:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27557

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

33

SAN 06/07/19

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/07/31

DL

33

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/07/31

33

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DL 06/07/31

33

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/09

33

Job Completion



h 06/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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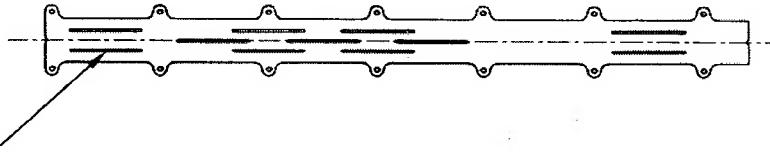
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WORK ORDER

NO. 27557

WITHOUT NOTICE

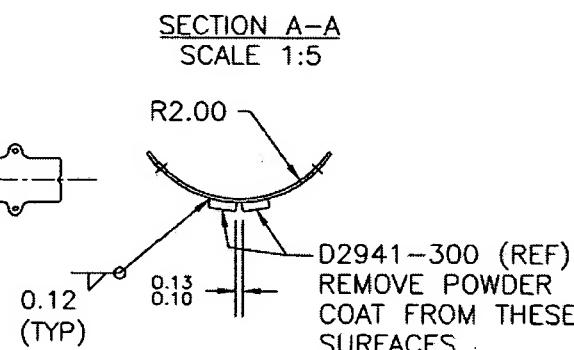
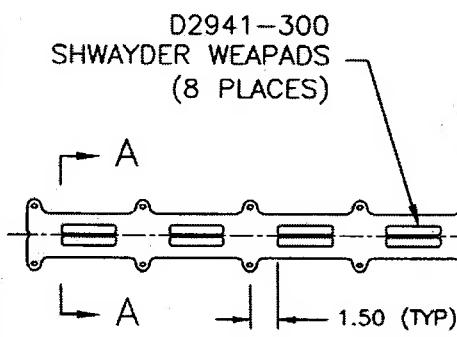
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN
off

DRAWN BY
GP

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. E
SHEET 1 OF 5
SCALE 1:10

DRAWING NO.
D2577

DATE
00.09.22

TITLE
WEARSHOE

A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-111/-13 INCORPORATE DE09176

RELEASED

Dec. 04 26 1996

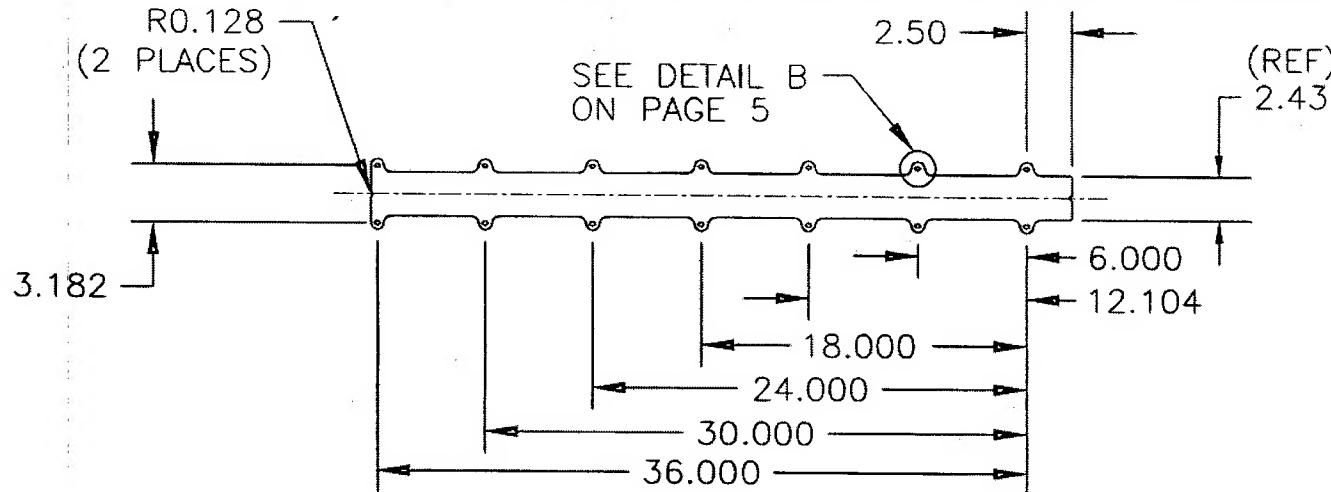
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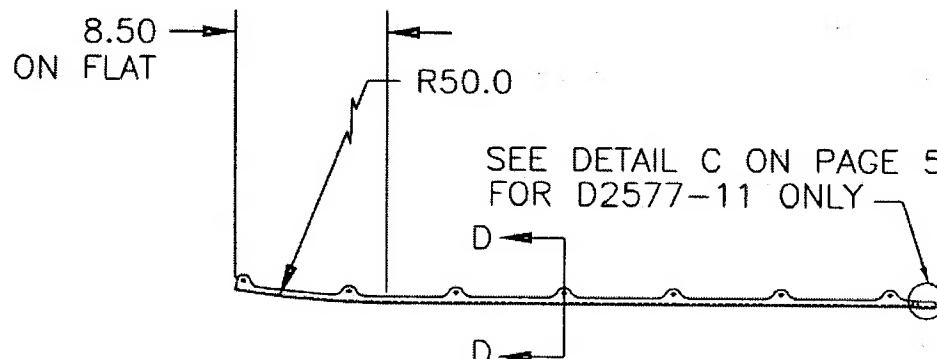


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

COPY
DATE
01-03-96

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DATE		REV. E TITLE WEARSHOE
00.09.22		SHEET 2 OF 5 SCALE 1:10

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08-02-96
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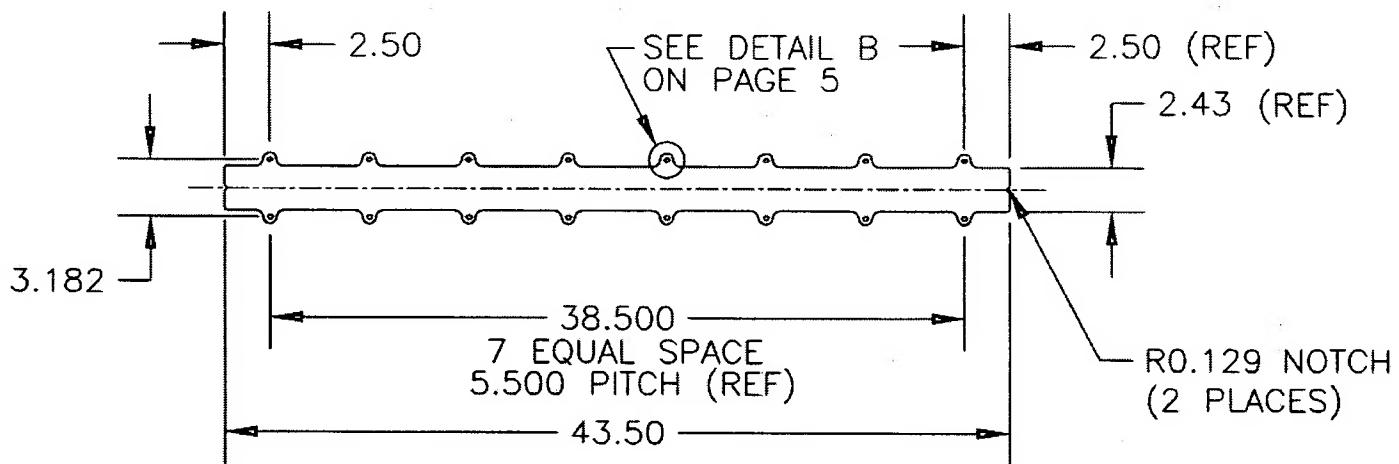
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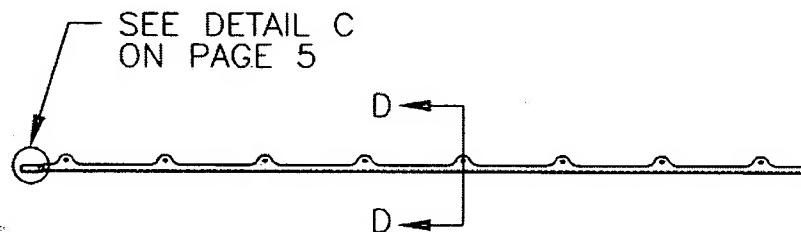
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		D2577
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 3 OF 5
		SCALE
		1:10

RELEASED
00.04.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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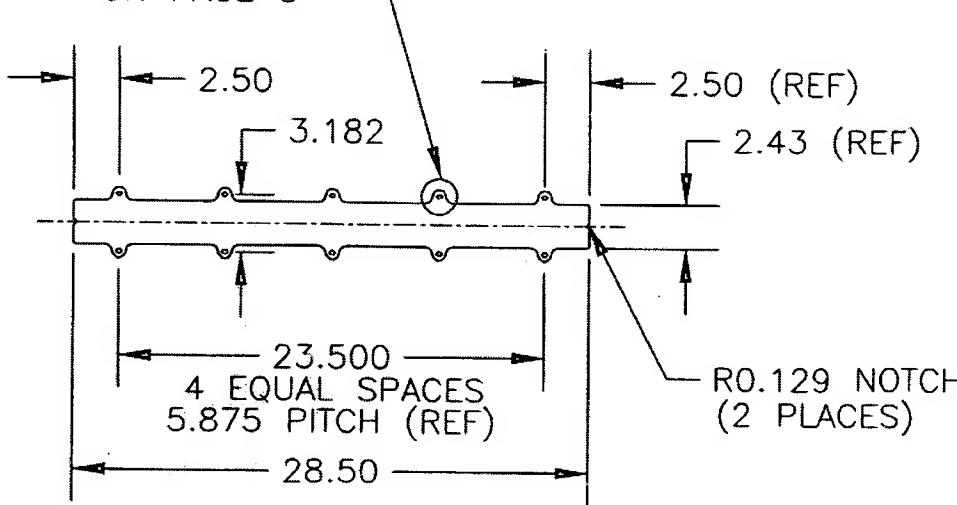


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DATE		SHEET 4 OF 5
00.09.22		SCALE 1:10
TITLE		WEARSHOE

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00.09.26

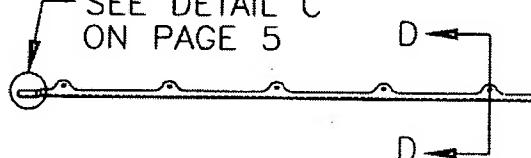
D2577-7 FLAT PATTERN

SEE DETAIL B
ON PAGE 5



D2577-7 LONGITUDINAL BEND

SEE DETAIL C
ON PAGE 5



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 27557
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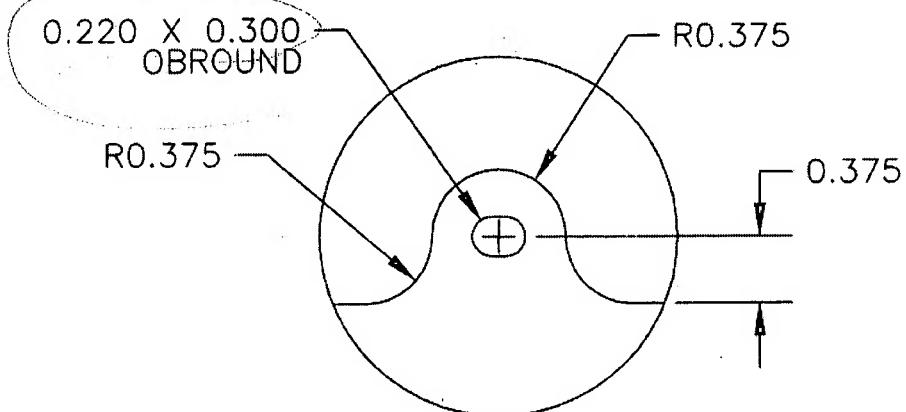


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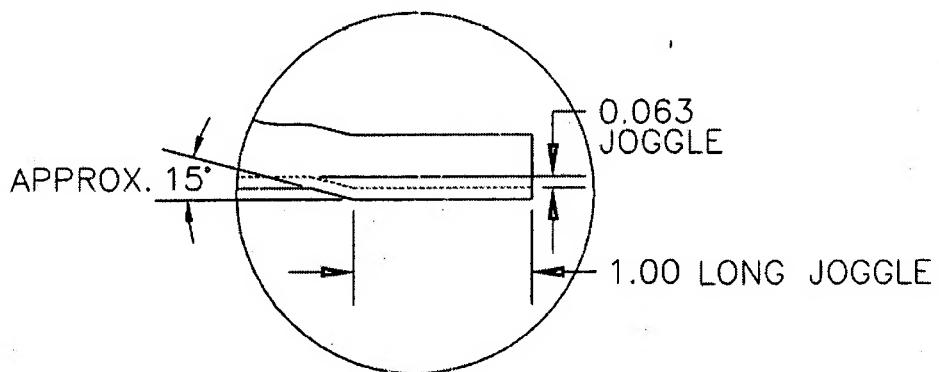
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DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	

DETAIL B (SCALE 1:1)

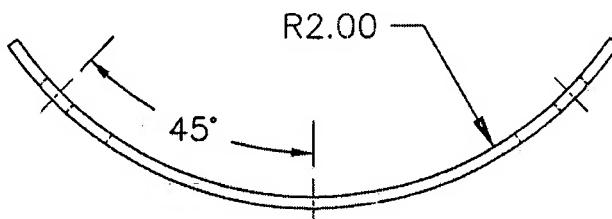
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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WORK ORDER
NO. 22551

DART AEROSPACE LTD	Work Order:	27557
Description:	Part Number:	D25775
Inspection Dwg: , Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	SAP	Audited by:		Prototype Approval:	
Date:	06.06.27	Date:	19.07.18	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	